

Date: Tuesday, 10/06/2008 12:54:33 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | WEARPAD |
| Job Number : | 39792 | | |
| Estimate Number : | 12784 | | |
| P.O. Number : | | Part Number : | D35649 |
| This Issue : | 10/06/2008 | Drawing Number : | D3564 REV D |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | / / | Drawing Revision : | D |
| Previous Run : | 38656 | Material : | |
| Written By : | | Due Date : | 23/06/2008 |
| Checked & Approved By : | JUD 08.6.10 | Qty: | 20 Um: Each |
| Comment : | Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



26.



Comment: Qty.: 1.1550 sf(s)/Unit Total : 23.1000 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 108156 HB 8-6-11

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: B
 Prog Rev: D HB 8-6-11

2-Deburr if necessary HB 8-6-11



| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



HB 8-6-11



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

5 08/06/11 counter 22

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155

SB 08/06/11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:33 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 39792

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

CP 08/06/16 (22)
S 08/06/16 counted (x22)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat H107962
Weld hardcoat as per Dwg D3564

08-06-19 SP

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/06/19 (x22)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/19 counted (x22)

10.0

POWDER COATING

POWDER COATING



M 106442



(22x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:20
320 °F
2:50

M-L 08/06/20

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/23 (22)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: PD-18

FL 08/06/23 (22)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:33 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 39792

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 39792 |
| Description: Wearshoe | | Part Number: D3564-9 |
| Inspection Dwg: D3564 | Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 3.227 | +/-0.010 | 3.227 | * | | | |
| 2.432 | +/-0.010 | 2.439 | * | | | |
| 2.50 | +/-0.030 | 2.50 | * | | | |
| 6.000 | +/-0.010 | 6.000 | * | | | |
| 12.104 | +/-0.010 | 12.104 | * | | | |
| 18.000 | +/-0.010 | 18.000 | * | | | |
| 18.000 | +/-0.010 | 18.000 | * | | | |
| 18.00 | +/-0.030 | 18.00 | * | | | |
| 9.00 | +/-0.030 | 9.00 | * | | | |
| 11.50 | +/-0.030 | 11.50 | * | | | |
| 0.300 x 0.300 | +/-0.010 | 301 x 304 | * | | | |
| Ø0.188 | +0.005/-0.001 | .190 | * | | | |
| R0.375 | +/-0.010 | 375 | * | | | |
| 0.063 | +/-0.010 | .058 | * | | | |
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|-----------------------|-----------------------|----------------------------|-----|
| Measured by: B | Audited by: S | Prototype Approval: | N/A |
| Date: 8-6-11 | Date: 08/06/11 | Date: | N/A |

| | | | | |
|------------|-------------|---------------|--------------------|-----------------|
| Rev | Date | Change | Revised by: | Approved |
| A | 08.01.16 | New Issue | KJ/EC/DD | DD |

8

7

6

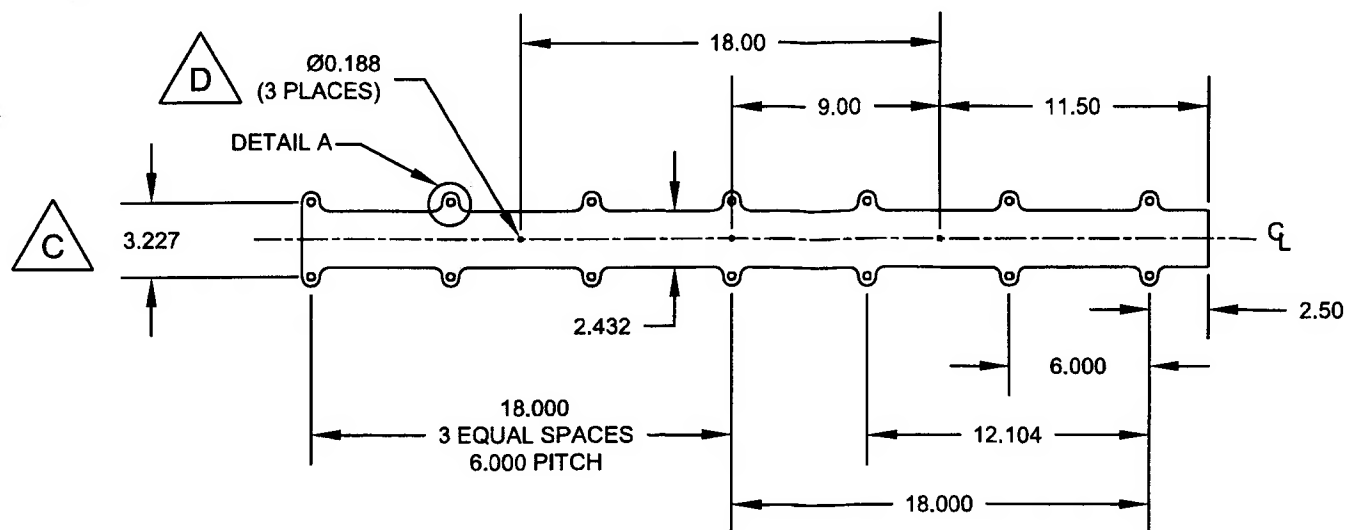
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4

3

2

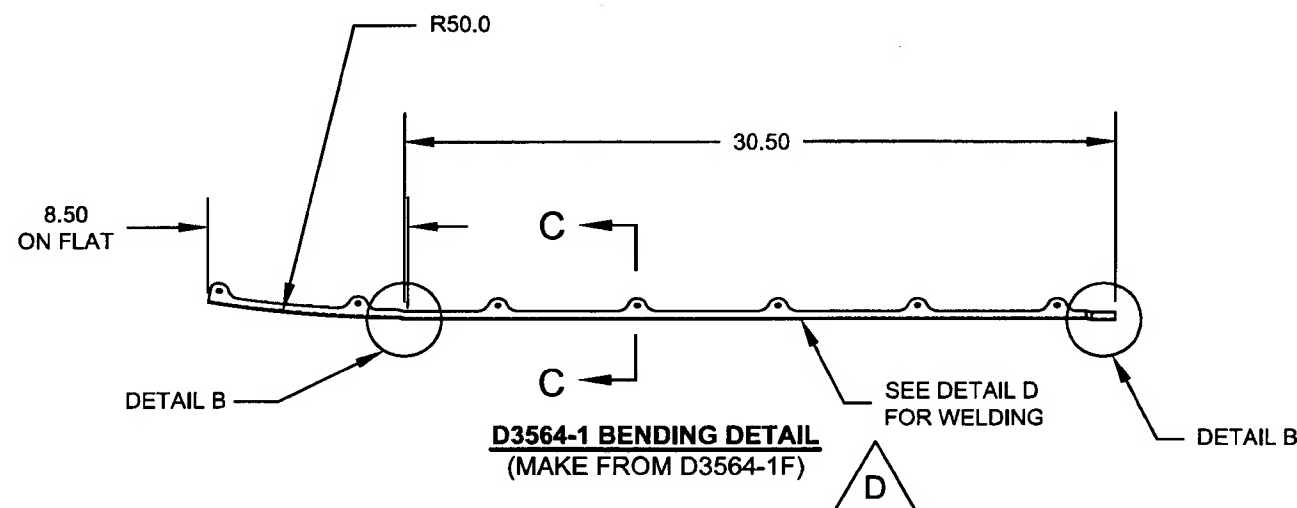
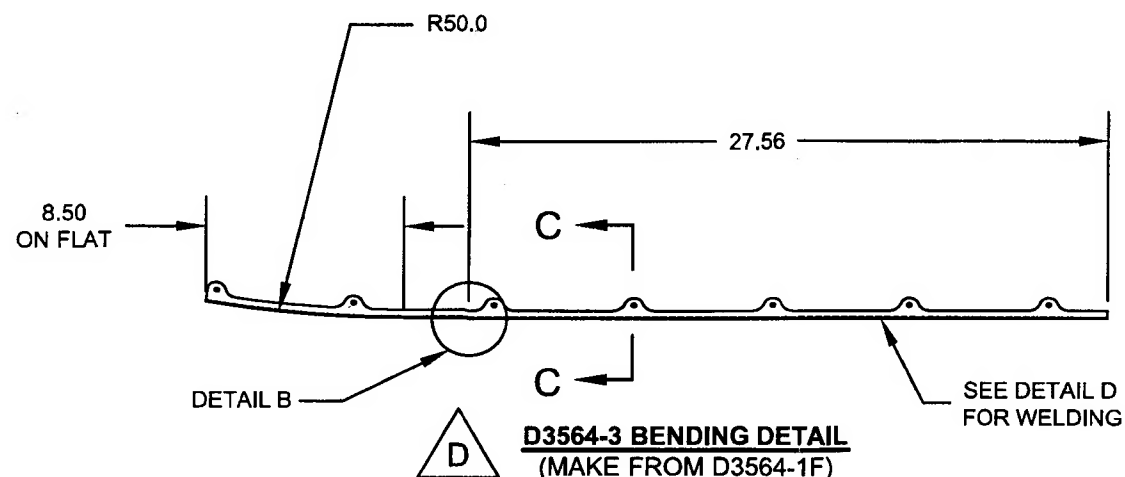
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D3564-1F FLAT PATTERN

RELEASED

07.09.04

D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3172

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

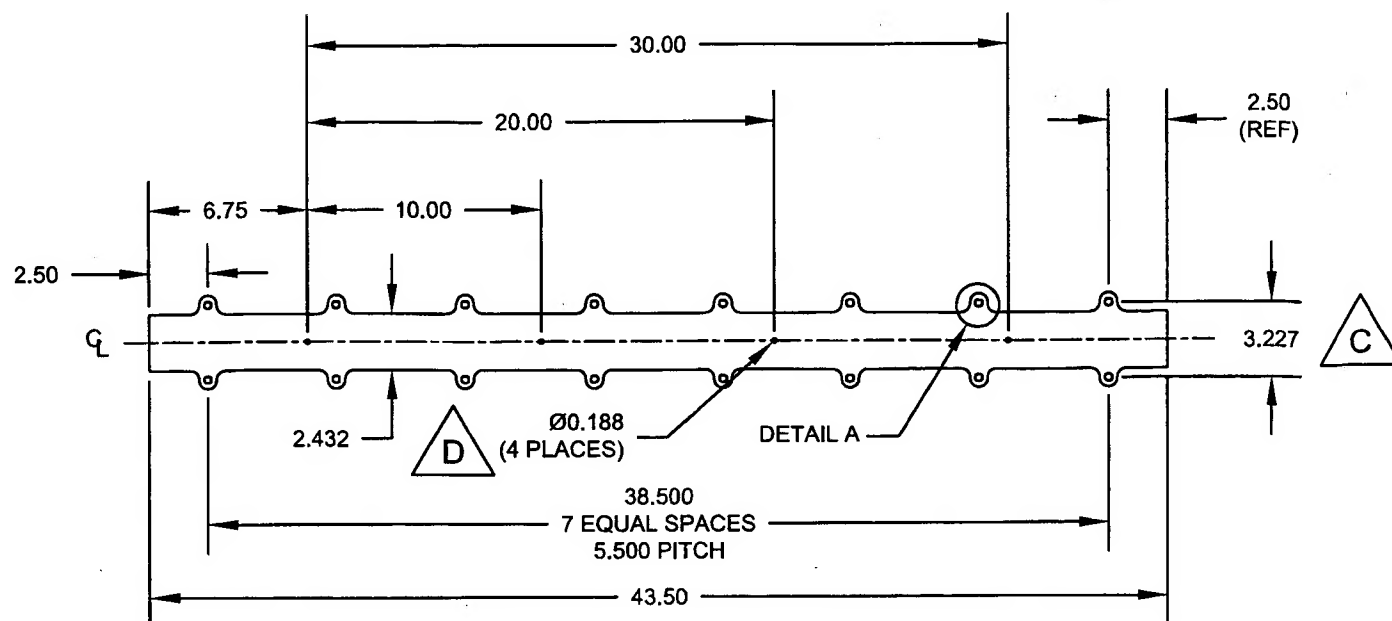
WEIGHTS:

| | |
|----------|----------|
| D3564-1 | 1.85 lbs |
| D3564-3 | 1.85 lbs |
| D3564-5 | 1.93 lbs |
| D3564-7 | 1.26 lbs |
| D3564-9 | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

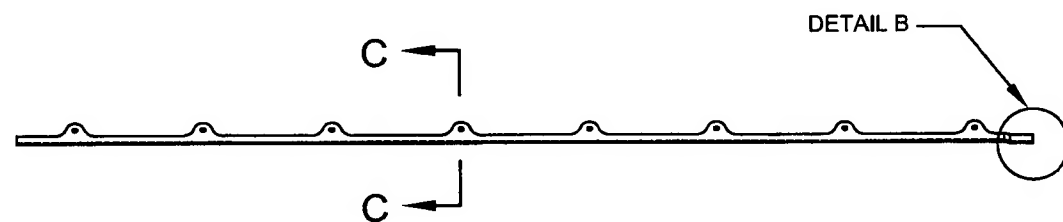
| | | | |
|------|--|----|----------|
| D | UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB | 07.08.21 |
| C | MOVE TAB OUTBOARD, DETAIL A | PH | 07.04.17 |
| B | ADD AMS 5513 AND AMS 5524 | PH | 07.03.20 |
| A | NEW ISSUE | PH | 06.12.18 |
| REV. | DESCRIPTION | BY | DATE |

| | | | |
|------------|----------|--|--|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | DRAWING NO. REV. D D3564 SHEET 1 OF 3 |
| DRAWN | CB | | |
| CHECKED | PH | | |
| MFG. APPR. | 21 | | |
| APPROVED | 12 | | |
| DE APPR. | 12 | TITLE SCALE WEARSHOE 1: | |
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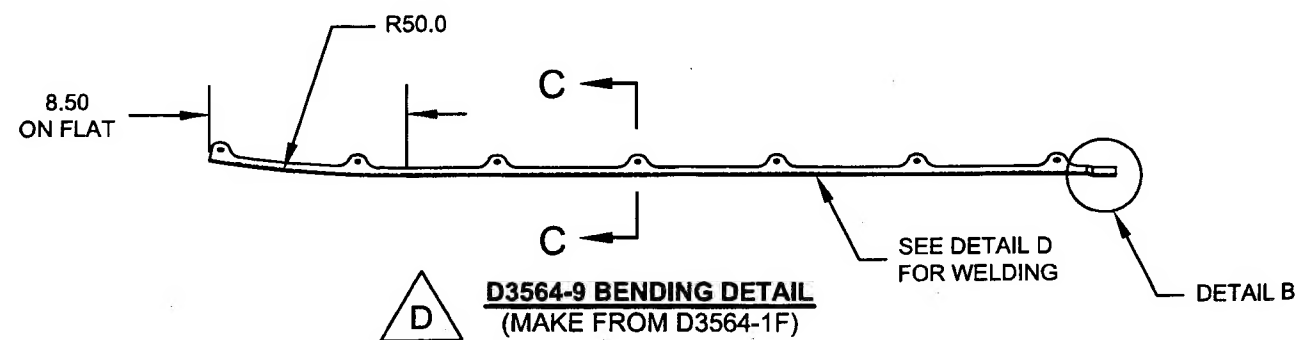
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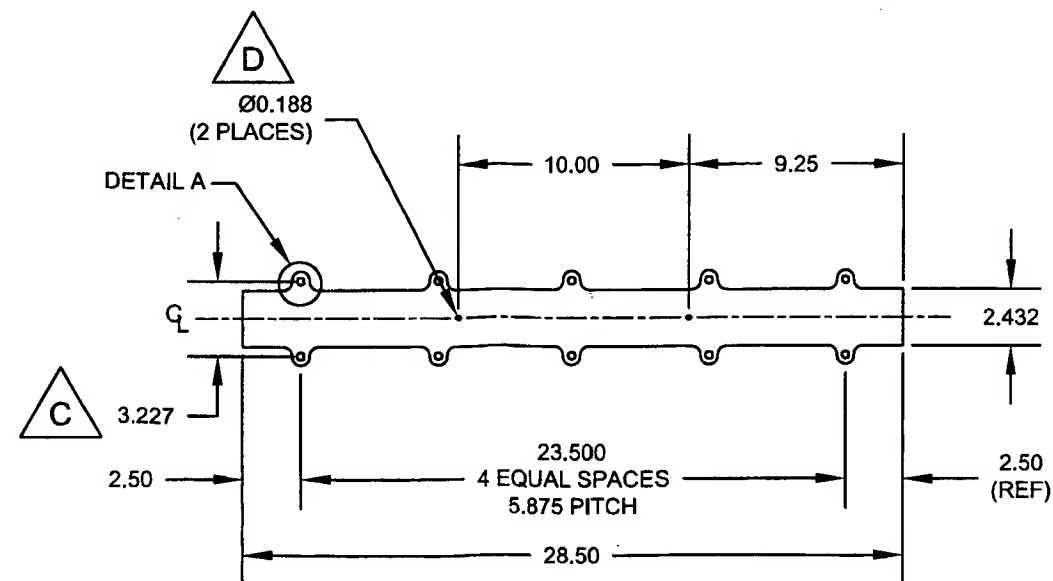
D3564-5F FLAT PATTERN



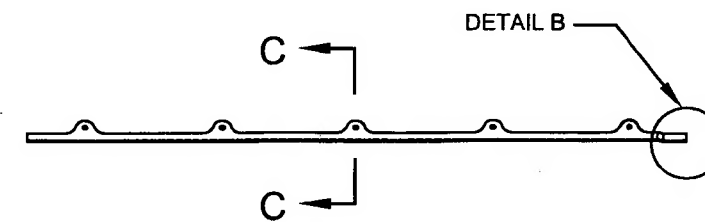
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



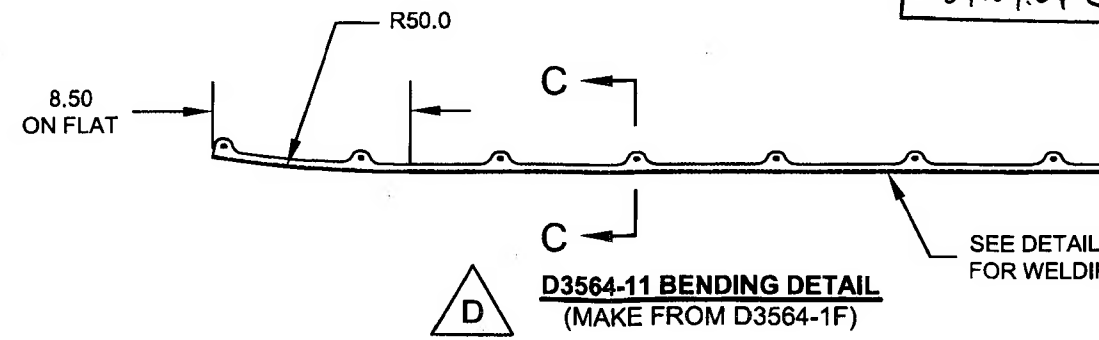
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

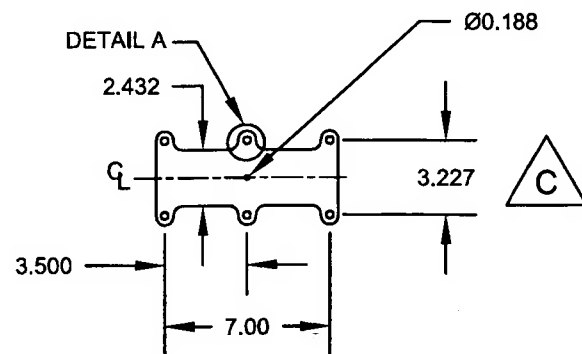
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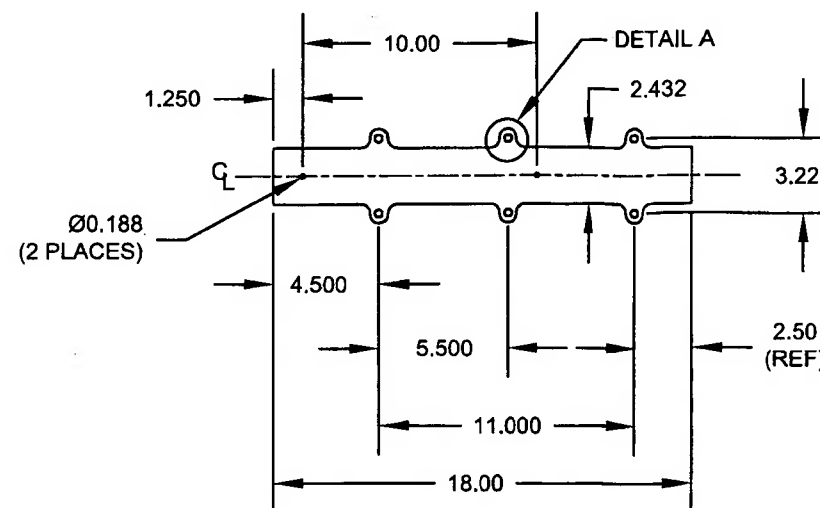
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| | | | |
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| DRAWN | C.B. | | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 2 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1:8 |
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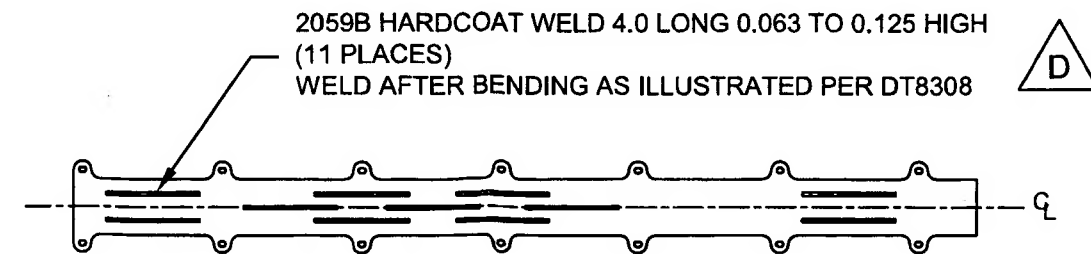
8 7 6 5 4 3 2 1



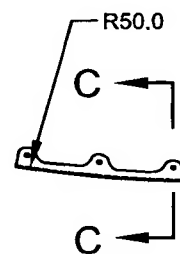
D3564-13F FLAT PATTERN



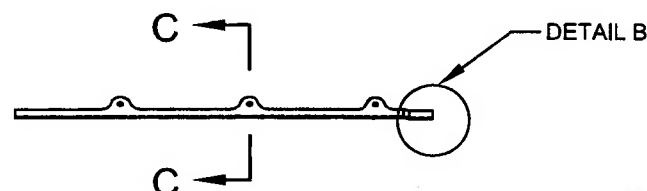
D3564-15F FLAT PATTERN



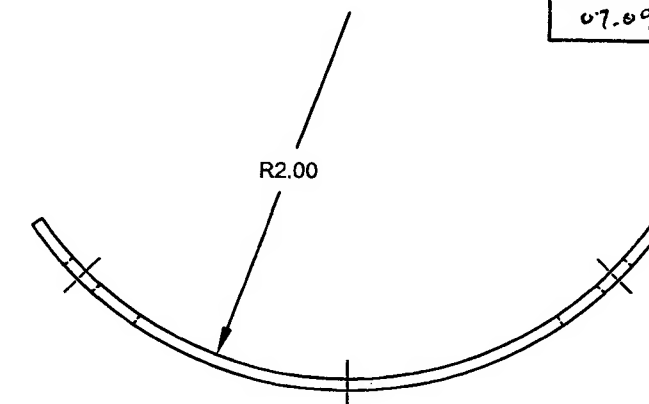
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



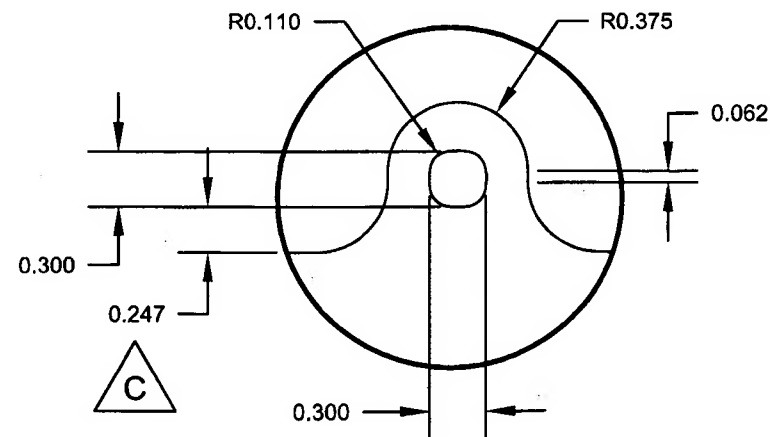
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



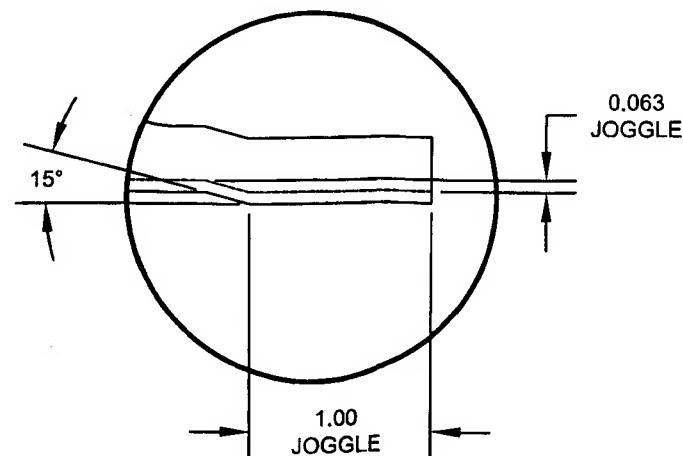
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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07.09.04

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WORK ORDER
NO. 39792

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| DRAWN | CB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | 21 | D3564 | SHEET 3 OF 3 |
| APPROVED | 160 | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1: |
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